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D4635-144
Job Sheet 186176



006751

Part No: D4635-144

Job Qty: 1 ea

Part Name: Aft Ceiling Replacement Panel Assembly, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/12/18

Job Tracking No:

Due Date: 11/30/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG D4635 REV F SHEET 12 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Doc Release DL IPP Rev. C Dwg. Update 13/07/09 DL ver:DD IPP Rev D Dwg Update 13/12/09 DL Ipp Rev. E Dwg Update 14/01/09 DL IPP Rev. F Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Container		SmB
110	Small Fab	1 pcs	11/30/18	11/30/18	0.00	1.57	Small Fab		SmB
120	QC	1 pcs	11/30/18	11/30/18	0.00	0.00	QC5		38
130	Packaging	1 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3		SmB
140	QC21-SA	1 Ea	11/30/18	11/30/18	0.00	0.00	QC21		DEC 05 2018

Part Op 110 - Assemble as per Dwg D4635-144 Bond foam core to inside of panel 3M Scotch Weld 1300
 Descriptions: Batch: m138715 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # m138958 Expiry Date April 19 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: m138961
 120 - QC5- Inspect part completeness to step on W/O
 130 - Identify as per dwg & Stock Location:
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4635-4 <u>fg 236</u>	Aft Ceiling Panel, RH	1 Ea (1 ea)	90-Start up Operation	<u>5130767</u>
D4669-1 <u>m1003</u>	Bracket	1 Ea (1 ea)	90-Start up Operation	<u>5130879</u>
D4695-4 <u>fg 236</u>	Channel	1 Ea (1 ea)	90-Start up Operation	<u>5005845</u>
D4732-11 <u>mf004</u>	Label	1 Ea (1 ea)	90-Start up Operation	<u>5060828</u>
D4732-39 <u>mf004</u>	Label	1 Ea (1 ea)	90-Start up Operation	<u>5060910</u>
D4732-41 <u>mf004</u>	Label	1 Ea (1 ea)	90-Start up Operation	<u>5060916</u>
D5022-5 <u>fg 236</u>	Foam, Side Panel, Aft	1 Ea (1 ea)	90-Start up Operation	<u>5017750</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4635-4	1	3	0
	D4669-1	1	34	0
	D4695-4	1	4	0
	D4732-11	1	6	0
	D4732-39	1	6	0
	D4732-41	1	6	0
	D5022-5	1	3	0
Part Specifications				
Specifications could not be found.				

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Container No: S134497

Part: D4635-144

Job No: 186176

Serial No/Batch: S134497

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/04/18

